Quality Control

Work Order I October-22-12 3:118	C 20 M 20	·	*920	74*						Page 1
Item ID: 647.1 Revision ID: Item Name: Angle Start Date: 22/10 Required Date: 05/11	0/2012 <b>Start Qty:</b> 1	17		*N900		100	<b>)*</b> s	Setup Star Stop	1.71	S1* S2*
Reference:		2.00 *12*  Date: 12-10-2		Customer:	ate:		R	Run Star	' *N	R1*
QC		Date:			ate:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b> 647.1800	Revision Nbr	:					····			
10			0.00				(8)			1B1L=11-2
*110* Waterjet FLOW CNC Waterjet		t as per Dwg Rev: 1	0.00				12	6		Jm 12-11
2024, 063	Prog	Rev: N/C burr if necessary								
<sup>20</sup> *12∩*	QC2- Inspect part	s off machine FAI/FAIB	0.00				(B)	<b>)</b>		B12-11-
QC QC	Mem	10	0.00				12	<b>©</b>		Jm 12-11

NCR:	Yes	/	No
NCR:	Yes	/	No

	DQA: Date:													
NCR: Y	es /	No					WORK ORDER NON-CONFORMANCE / UPDATE							
												QA Closed:	Date:	
Work Orde	r:						DISPOSITION				AGAINST	DEPARTMENT	/PROCESS	·
Part N	o. <u> </u>						Rework Scrap			Skid-tube Machining	Crosstube Small Fab	<del></del>	Water Jet d. Eng. Coor.	Engineering Quality
NCR No.							Use-as-is Work Order Update				Kec/Sto	re/Packaging Supplier	Other	
Root Desc							ption of work order update	ı	nitial	Act	tion	Sign &	1	
Cause		Date	Step	Qty		(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining	Data /Tooling ator prial o r ess lier ing													
							F	AUL	T CATE	GORY				
Landin	_				· ·.		General		•		_			
-  -  -  -  -	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube						Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Hardwa Inspecti Instruct Mainte	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Ripples in Bend						Drill Holes	П	Offset		L			1	
Torque Waves in Extrusion						Drawing		Out of Calibration						
Turning Sequence						Finish		Out of Sequence						

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

### Work Order ID 92074

October-22-12 3:18:51 PM

\*92074\*

Item ID: Revision ID: Item Name:	647.1813 Angle			Accept	*N900	<b>040</b>	100	<b>)*</b>	Setup Star Sto	I VI	S1*
	22/10/2012	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I	D:				IN.	S2*
Approvals:		ın:	Date:	Tooling: SPC (Y/N):		nte:		F	Run Stai Stoj	) )	R1* R2*
Sequence ID/ Work Center II	) , ,	Operation Description QC8- Inspect parts - seco		Set Up/F Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty -	Reject Number	Insp. Stamp
*130* QC Quality Control		Memo	ond check	0.00 Sas 12 [1-0]				12		<del></del>	pro
*140		Form as per dwg		0.00				i.m.			SAI
Brake NC Brake NC	·	Memo		0.00				10			
*150		QC5- Inspect part comple	eteness to step on W/O	0.00 <b>15</b>			,	P			
QC Quality Control		Memo		0.00 12 112	)			2			

Ç			
NCR: (	Yes	/	No

### WORK ORDER NON-CONFORMANCE / UPDATE

DQAC Date: 13	114		
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<del></del>										QA Closed:	Date:	(/
Work Order	: 64	<b>.</b> (	813	)	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
į		,			Rework	<b>]</b>		Skid-tube	Crosstube		Water Jet	Engineering
Part No	· <u>B</u>	920	<u> 44</u>		Scrap	Scrap Machining				Pro	d. Eng. Coor.	Quality
		210			<b>⊢</b> 1			noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR No	. 17	<u>- 719</u>	-		Work Order Update	╛╽		Large Fab	Composite	<u> </u>	Supplier	
	1	T	· · · · · · · · · · · · · · · · · · ·		<u> </u>							
Root		<u>.</u>	٥.	!	ption of work order update	1	nitial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data				Pa	A Creck of		242		14		. AO	OAS
Equip/Tooling	-			-11 °	On a did to		OAS	, Scrip	a dethoy		15 15 13 19 27	16
Operator Material	-	140	12	4 1	Ely d'Iland		9-65	nland	nedace	0	1258	
Setup	1/21/1/27	140	1	lest	well afferen	0.7	2007	100	70 10	D) 1	12112/	657042
Other	-			die	to find out	l Q	2042	B# (2)	4)	1/4/27		1211/27
Process	-			the	good Radin	121	11/27			10		
Supplier	-		,	mek	to find out good Radini e sure granding	dh			2 V			
Training	1		İ	in of	<b>'</b>			(h).	$\eta_{1}$		•	
Unapproved	1				·		1	, ,	X\6.			
<u> </u>	1	<u>!</u>	<u> </u>	l		FAUL	T CATE	GORY	1000	`	L	1
Landing	Gear				General			· · · · · · · · · · · · · · · · · · ·		<del>)</del>		
ľ	Bending				Bend		Grain		W W C	Ovalized		Pressure/Forced
	Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
<b>X</b>	Cracks			8	Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/0	Crimped.			Burrs	П	Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	$\searrow$	Part Moved		_
	Heat Trea	t			Countersink		Mislabe	led	, K	Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short		Misread	İ		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset			-		
	Torque W	xtrusio	<b>7</b>	Drawing	Out of Calibration							
	Turning Se	equence			Finish		Out of S	equence				
Wave/Twist in Tube					Folio		Outside Dimensions					

## Work Order ID 92074

October-22-12 3:18:51 PM

\*92074\*

Revision ID:	647.1813			Accept	*N900	<u> </u>	100	)* s	Setup Start	141.	31*
Item Name: Start Date: Required Date: Reference:	Angle 22/10/2012 05/11/2012	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item Customer				Stop	*NS	S2*
Approvals:	Process Pla	ın:	Date:	Tooling:		Date:	-	R	Run Start	IN F	₹1*
	QC:		Date:		1	Date:			Stop	*NF	<b>?</b> 2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description Outsource process-Anodi	70 mar OSI017 4 1 10 1	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*160* Outsource4 Outsource process -	Anodize	Memo ISSUE P/O:	////SDIZE, COLOR BLACK A	0.00 0.00 AS PER DWG.(SEE N	NOTE 2)				<u>pl</u>	12-10	7-/2
*170*		Receive & Inspect for Da	mage & Mat'l Certs	0.00						1	(14
Packaging Packaging		Memo		0.00		,			1-72	114	1 (18)
		*,	•								
*180		QC5- Inspect part comple	eteness to step on W/O	0.00 <b>15</b>	, ,			1,4)			
QC Ouality Control		Memo		0.00 / /.	191			/ ()			* *****

NCR: Yes	/	No

											DQA:	Date:	•	
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UPI	DATE	QA Closed:	Date:	•	
Vork Ord	or.					DISPOSITION				AGAINST DE	-		•	
Part No.									Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality	
NCR No. Description										Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root					Descri	iption of work order update		Initial	Act	ion	Sign &			
Cause		Date	Step	- Qty		or Non-conformance	Cr	ief Eng	Descr	ription	Date	Verification	QC Inspector	
oc/Data			ŀ											
uip/Tooling														
perator														
aterial														
tup	П	1		:										
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ocess														
pplier	П													
aining		]	[				1							
approved														
						F	AUI	T CATE	GORY					
· Landi	ing (	Gear				General								
		Bending				Bend		Grain			Ovalized Pressure/For			
Centre Not Concentric to O/S					o/s	BOM/Route		Hardwa	re		Over/Under tolerance Temperature/Cure			

ıaın	g Gear	General			
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	<del></del>
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
L	Ripples in Bend	Drill Holes	Offset		-
L	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
П	Wave/Twist in Tuhe	Folio	Outside Dimensions		

October-22-12 3:18:51 PM

\*92074\*

Page 4

Item ID: 647.1813 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Angle \*12\* **Start Date: Start Qty: 12.00** 22/10/2012 **Cust Item ID: Required Date:** 05/11/2012 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: \_\_\_\_ Date: \_\_\_\_ Approvals: **Tooling:** Date: Stop **Date:** SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID **Description Run Hours** Code Number Qty Qty Stamp 190 0.00 \*190\* SprayPaint 0.00 Memo. **Spray Painting** PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER BATCH: 123693 200 QC14- Inspect Spray Paint 0.00 \*200\* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: (37C 210 \*210\* Packaging 0.00 Memo Packaging \*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV\*\*\*

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											•		
μ			100								QA Closed	: Date:	
Work Ord	er:					DISPOSITION				AGAINST DI	PARTMENT	PROCESS	
Part No.  NCR No.  Root  Descri						Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing	Pro Rec/Sto	Engineering Quality Other	
Root					Descri	ption of work order update	ı	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш												
Operator													
Material	Ш												
Setup	Ш												
Other	Щ												
Process	Ш												
Supplier													
Training		!											
Unapproved													
	4					F/	AUL	T CATE	GORY				
Landi	ng G	Gear			<u> </u>	General					_		
	BendingE					Bend Grain			Ovalized		Pressure/Forced		
		Centre No	t Concer	ntric to (	2/5	BOM/Route	Hardware				Over/Linde	r tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

DQA:

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Date:

Weld

Other

Wrong Stock Pulled

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-22-12 3:18:51 PM

Item ID: 647.1813 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Angle **Start Date:** \*12\* 22/10/2012 **Start Qty: 12.00** Cust Item ID: **Required Date:** 05/11/2012 Req'd Qty: 12.00 **Customer:** Reference: Start Run **Process Plan:** Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: \_\_\_ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code Qty Qty Number Stamp 220 QC21- Final Inspection - Work Order Release 0.00 \*220\* QC 0.00 Memo Quality Control

											DQA:	Date	:
NCR:	Yes /	No				WORK ORDER NON-C	O	NFORM	MANCE / UPI	DATE			•,
											QA Closed:	Date	:
Work Orde	er.					DISPOSITION			,				
Part No			Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite			Small Fab Finishing	Pro Rec/Stor	Engineering Quality Other					
Root					Descri	ption of work order update	ı	Initial	Act	ion	Sign &		
Cause		ate	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling					:							-	
Operator													
Material													
Setup													
Other			*										
Process													
Supplier													
Training													
Unapproved													
	_					F/	AUL	T CATE	GORY				
Landi	ng Gea	•				General							
	Bei	nding				Bend	Π	Grain			Ovalized		Pressure/Forced
	Cei	ntre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cra	cks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	<del>  -</del>	Weld
	Cru	shed/0	rimped.			Burrs		1 '	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cut					Contamination		Mainte	•		Part Moved	·	
	He	at Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

#### . Picklist Print

· October-22-12 3:18:56 PM

Work Order ID: 92074

647.1813

Parent Item Name: Angle

\*92074\*

\*647 1813\*

**Start Date: 22/10/2012** 

**Required Date:** 05/11/2012

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

Parent Item:

IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	40.4700	0.088	1.111579	0 1.0		
*M2024T3	S-063*								**	1.111579			Jmiz-

Location Loc Qty Loc Code MAT022 40.47 119916 0.1 121197 16.32 123096 24.05

											DQA:	. Date:	
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	100	NFOR	MANCE / UP	DATE			₹.
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION							
Part   NCR	- No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Π	nitial	Ac	tion	Sign &		
Cause	l	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data							ĺ						
Equip/Tooling			j										ſ
Operator													
Material	П												
Setup	П												
Other '	П												
Process	П												
Supplier	П						1						
Training	П								-				
Unapproved	П												
						F	AUL	T CATE	GORY			•	
Landi	ng G	ear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	$\Box$	Centre No	ot Concer	atric to (	)/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	92074
Description: ANGIE	Part Number:	647-1813
Inspection Dwgt 47-1417 Rev: 1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	ACTUAL ACTUAL	· · · · · · · · · · · · · · · · · · ·	<u> </u>	Method of			
Dimension	1	Dimension	Accept	Reject	Inspection	Comments		
3,53	4 .005	3,534	2		VBOZ			
3,63	72 .005	12,627	2		V			
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<u>* .                                     </u>						<u> </u>		
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Measured by:	1B
Date:	12-11-27

Audited by:	15
Date:	15/1/01

Preliminary Approval:	
Date:	

	ENGINE	ERING CH	SHEET 1 DF 2							
l'APTCAL	DWG NE	]. 647.1800	RE'	V: N/C	prepared By B. PETE	.RS	DATE:	11/12/12	EFFECT ON DWG  SINC. OUNINC.	
INDUSTRIES, INC.		DWG TITLE: SHEETMETAL								
	APPROVED BY	ENGR F		MFG Da	in Barber	QC	4	EFF:	CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON:	REVISED	RADIUS	□N SH	EETMETAL	BEND.		ECK: D-12-02	0	
									2	

#### NOTES:

1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N

- 3. DEBURR AND BREAK ALL SHARP EDGES
- 4. IDENTIFY IAW MPP-120

# SHEET 1, ZONE A1 WAS:

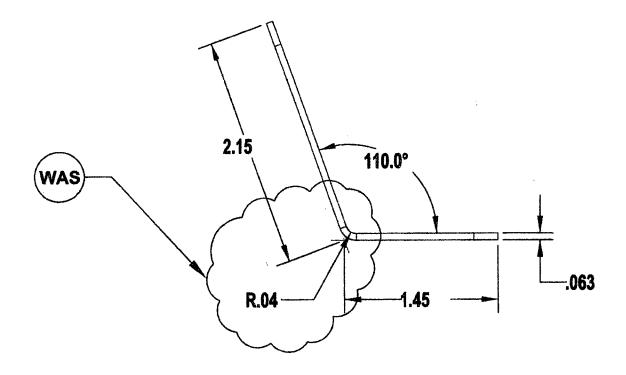
F/N TC	PART	NUMBER	QTY	DESC	RIPTION			MATERIAL		SPECIFICATION	
DOCUME	I STM	EFFECTED:	□ RFMS		☐ INSTALL INSTRU	UC 🗆 ICA	CHANGE D MAJOR	CATEGORY  MINOR	DER RE	VIEW REQUIRED ES 🖾 NO	

APICAL INDUSTRIES, INC.

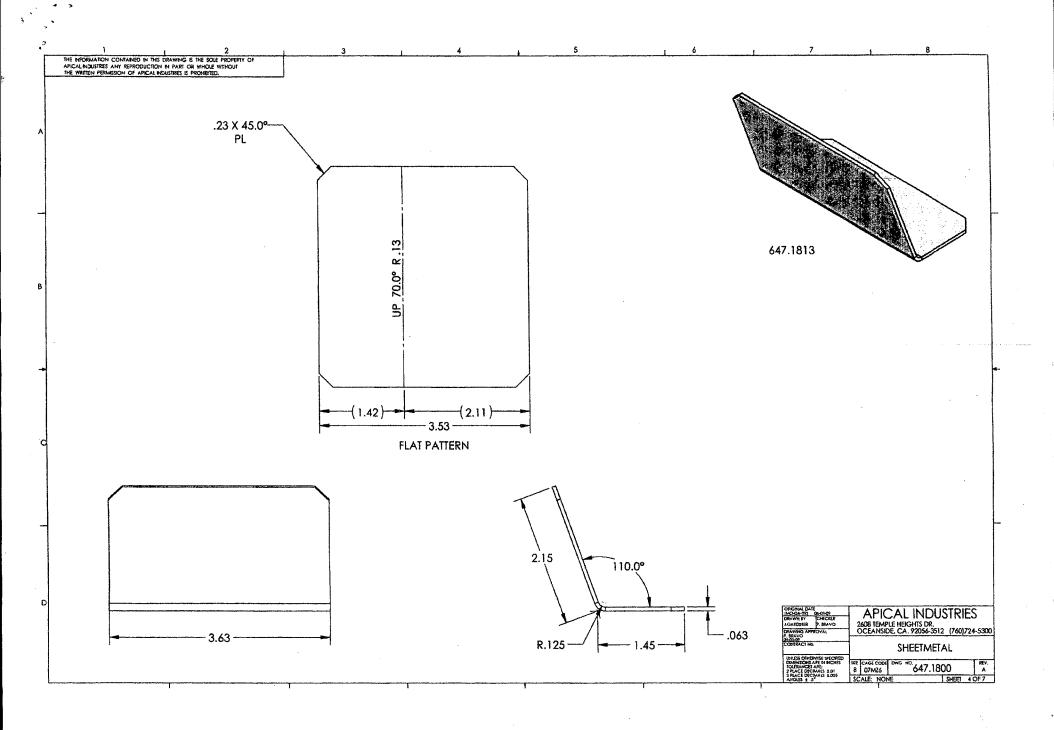
ENGINEERING CHANGE NO.

03686

SHEET 2 OF 2



**SHEET 4, ZONE D5 WAS:** 



DART AEROSPACE LTD	Work Order:	92074
Description: Angle	Part Number:	(111 11.2
Description. Angle	Pail Number.	697.1813
Inspection Dwg: 647.1800 Rev: 10/c		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.54"	11-0.010"	3.549"	<b>-</b> .		υ	Podwer
3.54° 3.63°	11-0.010"	3628	_		V	
0.063"	1/-0.010	0.063"	_	717	ν.	
023×645°	11-0.010"	0.23 x4	0 -		V + Prosection	
				2	÷.	
				:		
,						
		<u> </u>				

·	Ac	
Measured by: JM	Audited by: 5	Preliminary Approval:
Date: 12-11-1	Date: 12 //_0/)	Date:

Rev	Date	Change	Revised by Approved
E	10.04.14	Added preliminary approval	KJ



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

#### Pack List

Number: 62123

Date: 20-Dec-12

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAV KESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Pn. 613-632-32		Fax: 613-632-118	,	Ph: 613-632-5200	· · · · ·	13-632-1185	
Terms			Ship Via				
Quantity	Description						
lot	Part: ASST			Rev:			
	30 PCS D472 30 PCS <del>D476</del> 18 PCS 647. 10 PCS 646.	1813 1813 1813					
	12 PCS 647. HARD ANOD MIL-A-8625 T Job: 2012078	IZE BLACK YPE III CLASS 2	` PO: PO18645	Line:	:		
		Certificate of Co	onformance		ą,	,	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.						
	DATE : 20/	ISO 9001 : 2008 RI ATG SALES-2010 12/12 GNATURE :	TERMS APPLY				·
	RECEIVER SIG			<u> </u>			